

Work Order ID 150018

August 19, 2016 10:26:12 AM

150018

Page 1

Item ID: D2608 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket, 407 Console
 Start Date: 8/19/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/24/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: SJA Date: AUG 19 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2608	Rev A1								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.19							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.01							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.01							
Quality Control									

PR 2016/08/21
DAS 14 16/08/22
9-30

PR 2016/08/21
DAS 14 16/08/22
9-30

DAS 38 9-89
AUG 23 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
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Misidentified ☐	Past Due ☐																																																																

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Bend as per dwg NC BRAKE Memo	0.03 0.12							
					DAS 30 9-89	4			AUG 24 2016
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01							
						(4)			DAS 38 9-89 AUG 24 2016
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.18							
						(4)	✓		206/08/25 BEB

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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160 *160* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.01				(4)			DAS 38 9-89 AUG 25 2016
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>Stoopa</u> Memo	0.00 0.01				4			DAS 6 9-89 AUG 26 2016
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.07							AUG 29 2016

DAS
21
9-89

AUG 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Page 1

August 19, 2016 11:21:53 AM

Work Order ID: 150018

150018

Parent Item: D2608

D2608

Parent Item Name: Bracket, 407 Console

Start Date: 8/19/2016

Required Date: 8/24/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP E 02.06.05 Added alodine finish TSR 1290NG
IPP Rev F Added Rev.A 1 07-11-01 DD
IPP Rev:G now water jet 07-11-12 DD verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

sf

116.6000

3.6

M2024T3S 040

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

116.6

m134532

30.9

m135032

85.7

M134774

0.8

PR 2016/08/21
DAS
14
9-30
16/08/22

DQA: _____ Date: _____



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DART



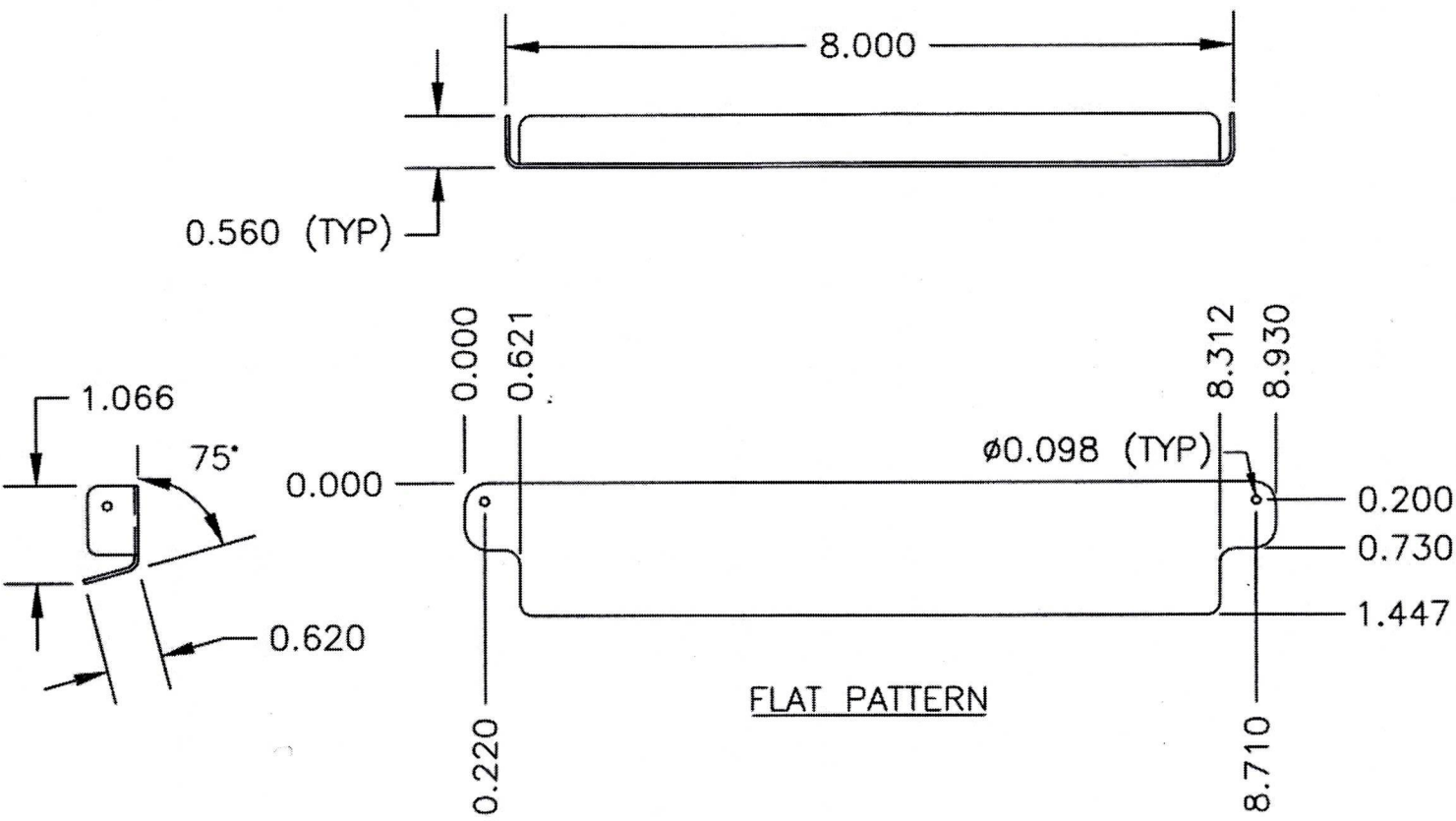
DESIGN	BW	DRAWN BY	BW	DART AEROSPACE LTD
CHECKED	KE	APPROVED	KE	VICTORIA INTERNATIONAL AIRPORT, CANADA
DATE	97.10.23	DRAWING NO.	D2608	REV. A
		TITLE	CONSOLE BRACKET	SHEET 1 OF 1
				SCALE
				1:2

A	97.10.23	D2608 WAS D206-547-25
A1	02.06.04	ADD FINISH

RELEASED
97.11.04 KE
TSR 4421

AUG 19 2016
150018

FLAT PATTERN



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2608
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



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DART AEROSPACE LTD	Work Order:	150018
Description: Bracket	Part Number:	D2608
Inspection Dwg: Rev A/	Rev: A/	Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by: PR		Checked by: 38		QC Inspector:	
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B	14.07.31	New Issue	KJ		